



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2807-041
Job Sheet 189312



Part No: D2807-041

Job Qty: 12 pcs

Part Name: Prop Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/11/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG REV E IPP: D 07.11.12 ecn1019, replaces D2807 EC verified by DD IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Purchasing	12 pcs	2/11/19	2/11/19	0.00	0.00	Purchasing - 1	FEB 05 2019
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	12 pcs	2/11/19	2/11/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	FEB 05 2019
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/05/19

Plex 2/5/19 12:18 PM Dart.Hadley.Shannon

					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	12 pcs	2/11/19	0.00 0.00	QC 6 - 38		
				QC 6 - 42		
				QC 6 - 9		DAS
				QC 6 - 68	MAK 12 2019	68
				QC 6 - 61		9-89
130 Small Fab - 2 - B4B	12 pcs	2/11/19	0.00 0.24	Small Fab - 1 - B4B		
				Small Fab - 2 - B4B		
				Small Fab - 3 - B4B		
				Small Fab - 4 - B4B	JUN 03 2019	
				Small Fab - 5 - B4B		
				Small Fab - 6 - B4B		
				Small Fab - 7 - B4B		
140 QC 5	12 pcs	2/11/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 38		
				QC 5 - 42		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		DAS
				QC 5 - 50	JUN 04 2019	40
				QC 5 - 30		9-89
150 Packaging 3-1 - Stock - B4B	12 pcs	2/11/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		

Plex 2/5/19 12:18 PM Dart.Hadley.Shannon

				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC ST 11
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	12 pcs	2/11/19	0.00 0.00	QC 21 - SA - 21	046 21 JUN 05 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	0-05
Part Op 100 - Purchasing - Issue P/O: _____ Order as per Dwg D2807 Possible supplier: Lift Support Descriptions: Technologies, Saskatoon, Canada P/N 6/15-164/50-115N 110 - Receive & Inspect for Damage & Mat'l Certs - Ensure Material Release Note is attached 120 - QC6- All purchased or subcontracted products 130 - Small Fab - 1-install D3671-1 as per dwg D2807 140 - QC5- Inspect part completeness to step on W/O 150 - Identify as per dwg & Stock Location: _____ 160 - QC21- Final Inspection - Work Order Release					
PO Details					
LS Technologies Inc. (1st001-vc)  PO No: PO042378 Line No: 1					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
6/15-164/50-115N	Gas Spring D2807-041	12 pcs (1 ea)	100-Purchasing	S/S 1006 S163851	
D3671-1	Placard	12 pcs (1 ea)	130-Small Fab - 2 - B4B		
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Purchasing	6/15-164/50-115N	12	0	0	
130-Small Fab - 2 - B4B	D3671-1	12	23	0	
Part Specifications					
Specifications could not be found.					

Plex 2/5/19 12:18 PM Dart.Hadley.Shannon



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

12568

D2807-041 Job Sheet 189312



Part No: D2807-041

Job Qty: 12 ea

Part Name: Prop Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/11/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: DWG REV E IPP: D 07.11.12 ecn1019, replaces D2807 EC verified by DD IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	12 pcs	2/11/19	2/11/19	0.00	0.00	Purchasing		
110	Packaging	12 pcs	2/11/19	2/11/19	0.00	0.00	Packaging2		
120	QC	12 pcs	2/11/19	2/11/19	0.00	0.00	QC6		
130	Small Fab	12 pcs	2/11/19	2/11/19	0.00	0.24	Small Fab-2		
140	QC	12 pcs	2/11/19	2/11/19	0.00	0.00	QC5		
150	Packaging	12 pcs	2/11/19	2/11/19	0.00	0.00	Packaging3-1		
160	QC21-SA	12 Ea	2/11/19	2/11/19	0.00	0.00	QC21		

Part Op 100 - Issue P/O: 042378 Order as per Dwg D2807 Possible supplier: Lift Support
Descriptions: Technologies, Saskatoon, Canada P/N 6/15-164/50-115N
110 - Ensure Material Release Note is attached
130 - 1-install D3671-1 as per dwg D2807

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
6/15-164/50-115N	Gas Spring D2807-041	12 pcs (1 ea)	100-Purchasing	
D3671-1	Placard	12 Ea (1 ea)	130-Small Fab	

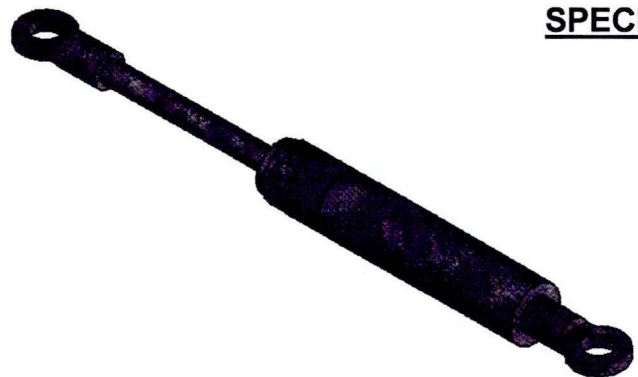
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	6/15-164/50-115N	12	0	0
130-Small Fab	D3671-1	12	39	0

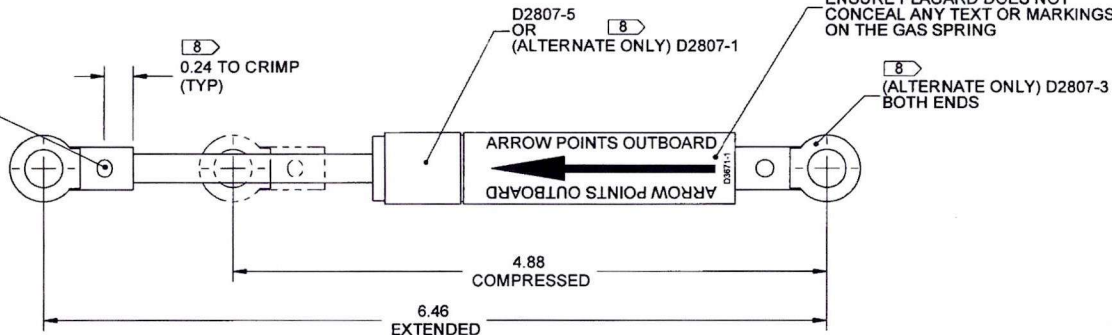
Part Specifications

Specifications could not be found.

SPECIFICATION CONTROL DRAWING



(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH $\phi 0.375$ TOOL AT
2000psi (REF), TYP TWO
SIDES PER LUG



D2807-041 GAS SPRING

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

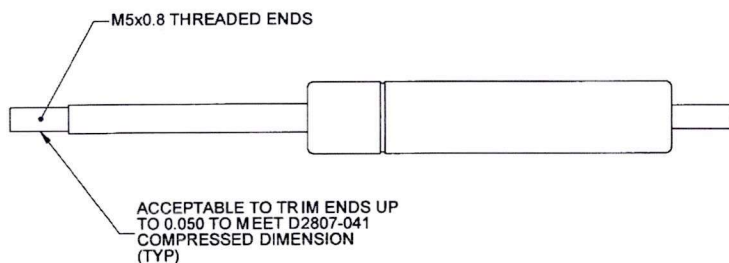
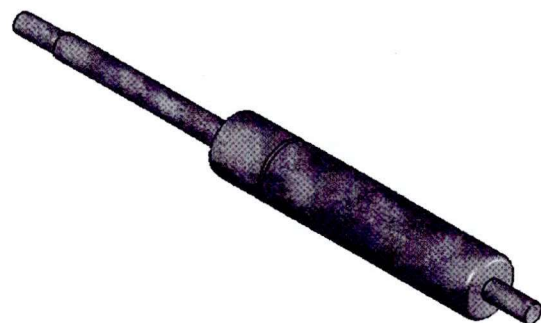
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)
(WEIGHT: 0.176 LBS)

E

E	ADD D2807-5 GAS SPRING; D2807-1-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.	W.D.	D2807	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GAS SPRING	NTS
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

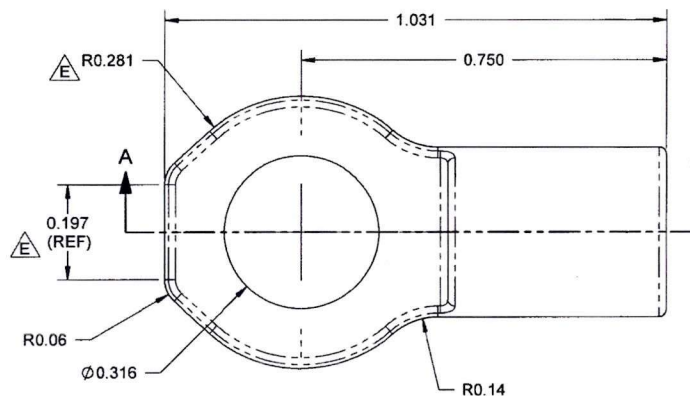
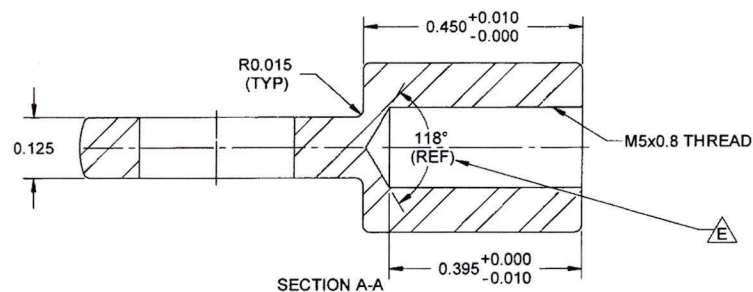
RELEASED
08-12-11



D2807-1 GAS SPRING
SCALE 1:1

D2807-1 GAS SPRING NOTES:

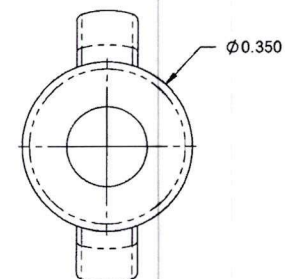
- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS



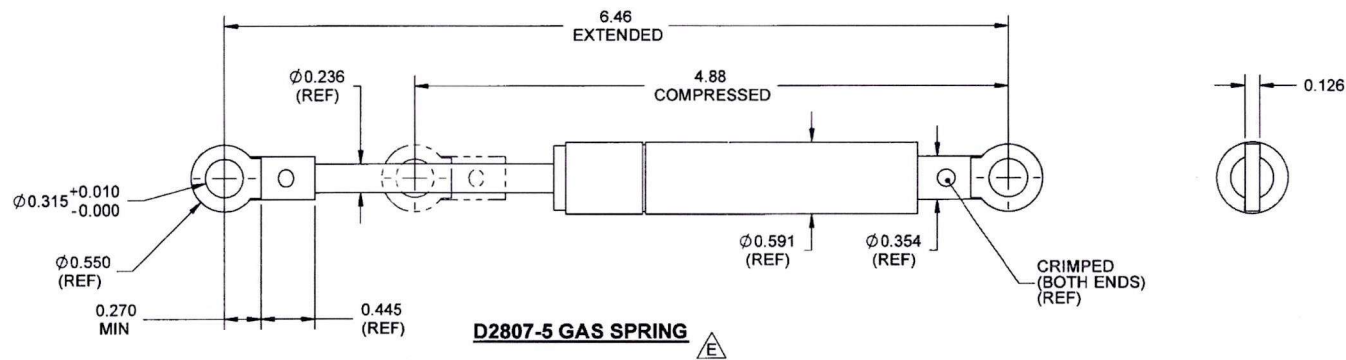
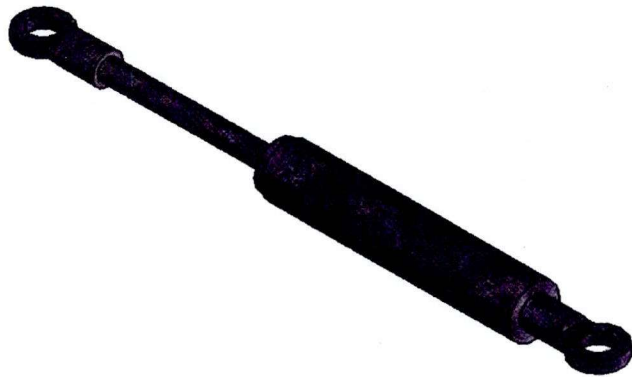
D2807-3 LUG

D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS



DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. E
MFG. APPR.	LE	D2807	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



D2807-5 GAS SPRING

D2807-5 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA (P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS.
ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.	KE	D2807	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
08-02-12

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042378



Supplier: LST001-VC
LS Technologies Inc.
1634 Saskatchewan Ave.
Saskatoon
SK
S7K 1P6 Canada
Phone: 306 683 5000
Fax: 306 683 6403

PO No: PO042378

PO Date: 1/23/19

Due Date: 2/12/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
JAN 24 2018

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189312	6/15-164/50-115N			Gas Spring D2807-041 As per Dwg D2807 Rev. E	Firmed	-	2/12/19	12 pcs	0 pcs	12 pcs	\$72.13/pcs	\$865.56
Grand Total:													\$865.56

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 1/23/19 3:24 PM dart.tsimiklis.chrisoula

Packing Slip

LS TECHNOLOGIES INC
1634 Saskatchewan Ave
Saskatoon, SK S7K 1P6

P.O. No.	Date	Invoice #
042378	1/28/2019	19697

Bill to:

Dart Aerospace Ltd
1270 Aberdeen St.
Hawkesbury, ON K6A 1K7

Ship to:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St.
Hawkesbury, ON K6A 1K7

Ship	Via
1/14/2019	Fed-Ex

Qty	Description
12	D2807-041 #189312 Stainless Gas Spring (6/15-164/50-115N)
	Shipping Via FED EX Tracking # 774325939409

Order checked by :





LS Technologies Inc

1634 Saskatchewan Ave,
Saskatoon, SK S7K 1P6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

Jan 28, 2019

This is to certify that the parts listed below meets specifications as required by your order.

12 Units : D2807-041 #189312 Stainless Gas Spring (6/15-164/50-115N)

Country of Manufacture: Canada

Date of Manufacture : Jan 2019

This product is ROHS compliant.

Purchase Order # 042378

Invoice # 19697

L S Technologies Inc Canada

A blue ink signature of Nolan Fehr, written in a cursive style, positioned above a horizontal line.

Nolan Fehr
President